

Work Order ID 76997

November-24-11 2:48:51 PM

76997

Page 1

Item ID: D3041-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 24/11/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 11/11/24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3041	Rev C								

100 BAND SAW 0.00
100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut D2423 Extrusion: 1.250" Long
cut @ meter

CL 11/11/28

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 HAAS I *Purch* Memo 0.00
 HAAS CNC vertical machine #1 Check for cracks while loading into the machine
 Machine as per Folio FA153 and Dwg D3041
 DWG REV: _____
 FOLIO REV: _____
issue Pro to meter machine as per dwg D 3041 REV.C

CL 11/11/28

PO: 15552

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC *Rec'd* Memo 0.00
 Quality Control

*Rec'd + inspect for transit damage
 attached C of C to W/O*

10/11/26 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8-Inspect parts - second check Memo	0.00 0.00				count (+24)			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

Mask inside of 0.8120" diameter hole
 START TIME: 9:15
 OVEN TEMPERATURE: 320 OF
 FINISH TIME: 9:45

M 119480

24X4 M 11/12/14

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				24x COUNTED	4	11/12/11	
170 *170* Small Fab Small Fab	Small Fab Memo 1- Press D2611 bearing into lug as per Dwg D3041 using DT 9472 2- Stake bearing into place as per Dwg D3041 using DT9456 3-Touch up stake marks with white emeron paint	0.00 0.00							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

Handwritten signature and date: 11/12/20

Handwritten notes: counts 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: ST 4/2	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

(24x) SP 11-12-21.

11/2/21
MF
11-12-21

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Picklist Print

November-24-11 2:48:55 PM

Page 1

Work Order ID: 76997

76997

Parent Item: D3041-3

D3041-3

Parent Item Name: Clamp

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: A01.07.11New IssueSM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No			100	Each	30.0000	1	24			
D2611									**				
Bearing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST018		30		B77485					
				68916		30							
D2423		Manufactured	No			170	f	447.8800	0.1042	2.632421			
D2423									**				
Lug Extrusion													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		447.88							
				43722		161.5							
				45800		1							
				68331		285.38							

D 3041-37

x 24

_____ 24/7/6 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

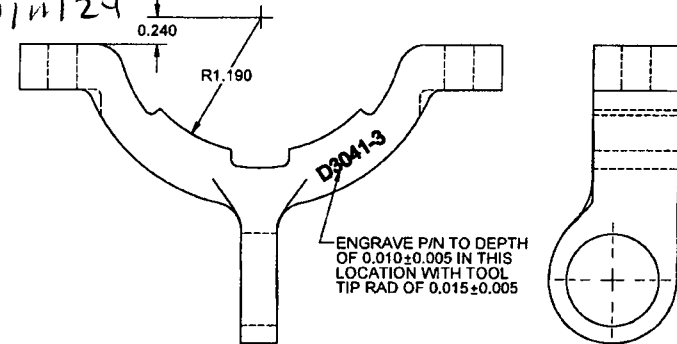
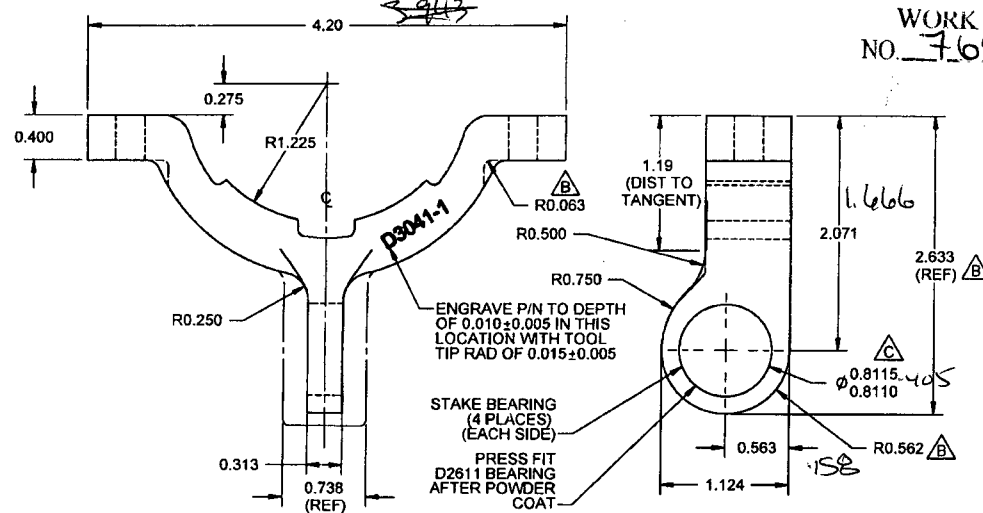
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

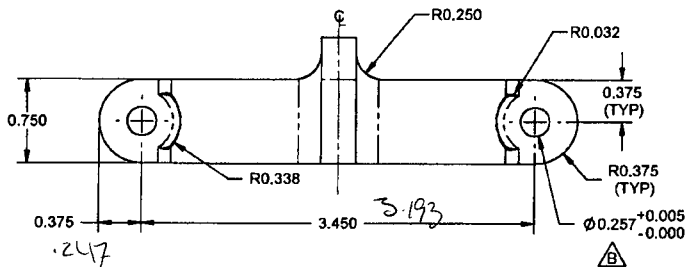
WORK ORDER
NO. 76997 M.C.J
11/11/24



DEO ATTACHED

RELEASED

06.11.17



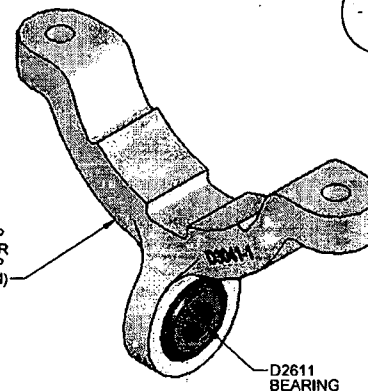
D3041-1 CLAMP

D3041-3 CLAMP
(SAME AS D3041-1
EXCEPT AS SHOWN)

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) STAKE D2611 BEARING AFTER POWDER COAT
- 7) PART IS SYMMETRIC ABOUT C

D3041-1 CLAMP
(SHOWN) OR
D3041-3 CLAMP
(NOT SHOWN)



D2611
BEARING

C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3041
DATE	06.10.18	TITLE CLAMP
		REV. C SHEET 1 OF 2 SCALE 1:1

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W/O:		WORK ORDER CHANGES					
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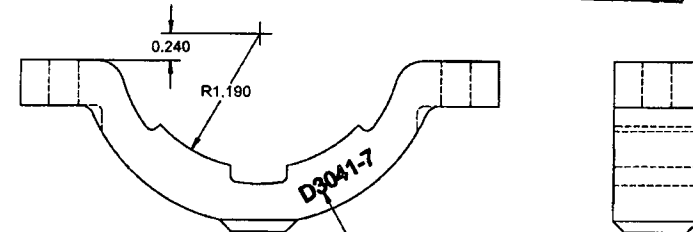
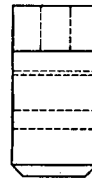
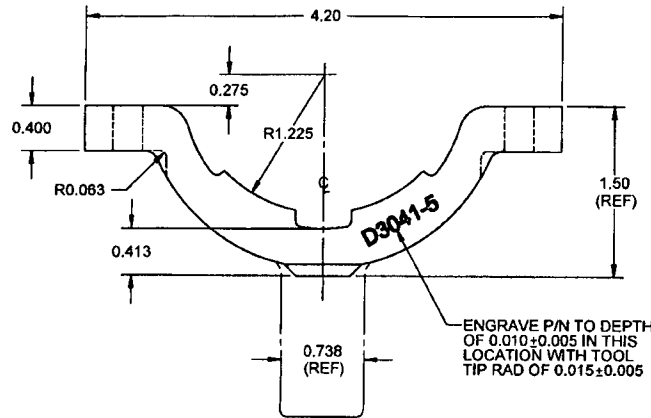
NOTE: Date & initial all entries

76997

DEO ATTACHE

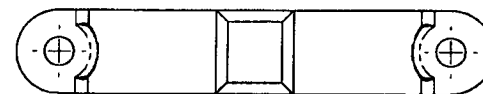
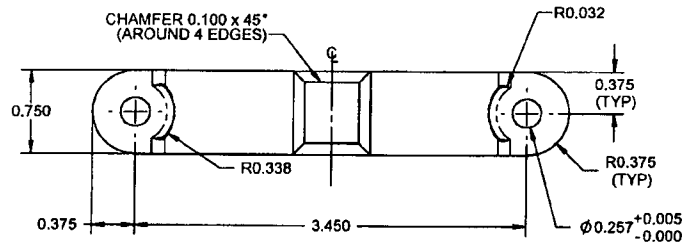
RELEASED

06.11.17



ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005

ENGRAVE P/N TO DEPTH OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP RAD OF 0.015±0.005

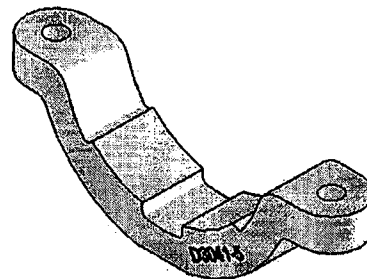


D3041-5 CLAMP

D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

NOTES:

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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT C



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	06.10.18	D3041	SHEET 2 OF 2
TITLE		CLAMP	SCALE
			1:1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

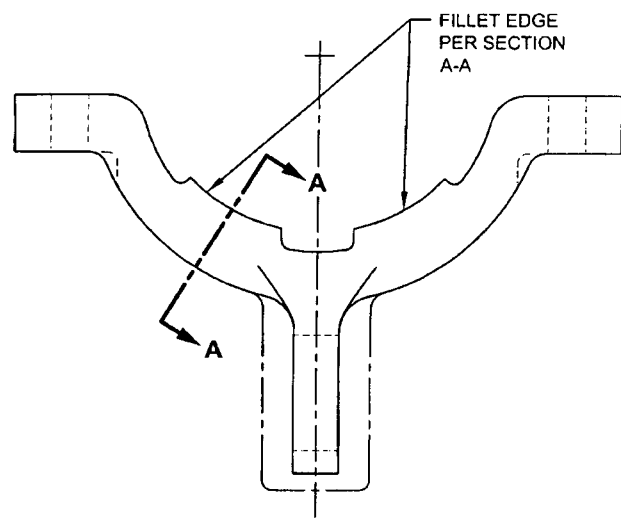
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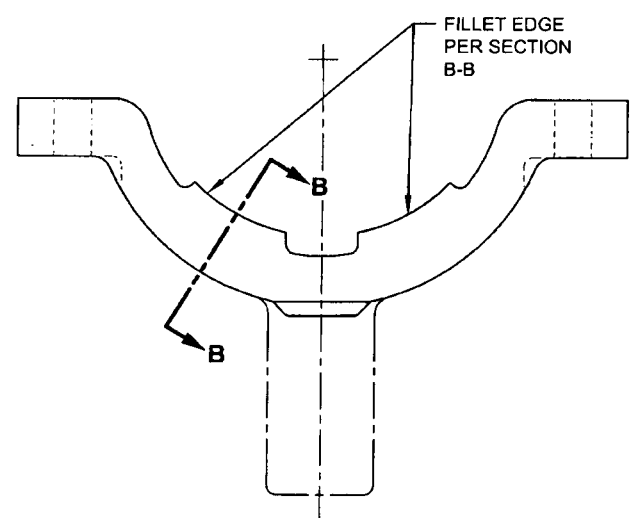
76997

DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

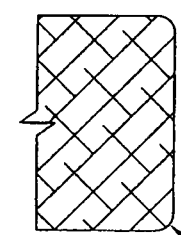
ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP
D3041-3 CLAMP



D3041-5 CLAMP
D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A
SCALE 2X
SECTION B-B
SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15552

Purchase Order Date 11/28/11

PO Print Date 11/28/11

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

RECEIVED
\$

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3041-1P	Clamp	12/09/11 Yes	24.00 Each	Dart Truck	\$42.0000	\$1,008.00
		Special Inst:	AS PER DWG D3041 REV. C B77050				
2	D3041-3P	CLAMP	12/09/11 Yes	24.00 Each	Dart Truck	\$42.0000	\$1,008.00
		Special Inst:	AS PER DWG D3041 REV. C B76997				
PO Total:							\$2,016.00

Change Nbr: 2

Change Date: 11/28/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18301
Date: Dec 06, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 15552	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date: Dec 06, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp as per Dwg D3041 REV.C B77050	Each	24	24	
D3041-3 Clamp as per DWG D3041 REV.C B76997 Materials supplied by Dart	Each	24	24	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
24	D3041-1P	Clamp	PO15552
24	D3041-3	Clamp	PO15552

MATERIAL: supplied by DART D3041 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, December 6 2011